

Date: Friday, 16/05/2008 7:50:14 AM
 User: Linda Lacelle

Process Sheet

Split
 8 00105/21

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : WEARPLATE
 Job Number : 39313
 Estimate Number : 10606
 P.O. Number :
 This Issue : 16/05/2008 S.O. No. :
 Prsht Rev. : NC Part Number : D33193
 First Issue : / / Type : SMALL / MED FAB Drawing Number : D3319 REV. B
 Previous Run : 38091 Material : B
 Due Date : 23/05/2008 Qty: 3 Um: Each
 Written By :
 Checked & Approved By :
 Comment : Est: A 05/05.12 New issue KJ/JLM
 Est Rev: B Now on Waterjet 06-10-03 JLM

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 M1010S18GA 1010/1025/A21/6aA SHEET .048



Comment: Qty.: 3.4150 sf(s)/Unit Total : 40.9802 sf(s)
 1010/1025/A21/6aA SHEET .048" Thick
 Batch: 106603 HB 8-5-20

2.0 WATER JET FLOW WATER JET



Comment: FLOW WATER JET
 1-Cut as per Dwg D3319
 Dwg Rev: B HB 8-5-20
 Prog Rev: B

2-Deburr if necessary HB 8-5-20

3.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0 QC8 SECOND CHECK



Comment: SECOND CHECK

5.0 SMALL FAB 1 SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1
 Deburr if necessary

Done at step # 2.2
 2008/5/21

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: WEARPLATE

Job Number: 39313

Part Number: D33193

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

BRAKE NC

NC BRAKE



Comment: NC BRAKE

Form using DT8326 & DT8261 as per Dwg D3319 Rev: B

SP 08/05/21 (3)

7.0

QC6

DIMENSIONAL CHECK



Comment: DIMENSIONAL CHECK

S 08/05/21 (43)

8.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

Weld hard surface using D3319-3T2 per QSI 004 and Dwg D3319 Rev: _____

Qty	Part Number	Description	Batch
A/R	N/A	7560 Hardcoat Rod	M106762

Batch

VISUAL INSPECTION OF GROUND WELDS

9.0

QC10



Comment: VISUAL INSPECTION OF GROUND WELDS

S 08/05/21 (43)

10.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

S 08/05/21 (43)

11.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

1:45 PM
320 OF
2:15 PM

M105642

M.L 08/05/21

12.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

FD 08/05/21 (3)

13.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify on inside surface using a permanent fine point marker with the following:
TCCA-PDA, Dart Aerospace Ltd.

8/5/21

SP

Friday, 16/05/2008 7:50:14 AM
Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: WEARPLATE

Job Number: 39313

Part Number: D33193

Job Number:



Seq. #:

Machine Or Operation:

Description :

P/N: D3319-3, B/N: BXXXXX
For Product Eligibility see PDA05-18
and Stock
Location: ST- 996

8/5/21

(3x)
SEP

14.0

QC21

FINAL INSPECTION/W/O RELEASE



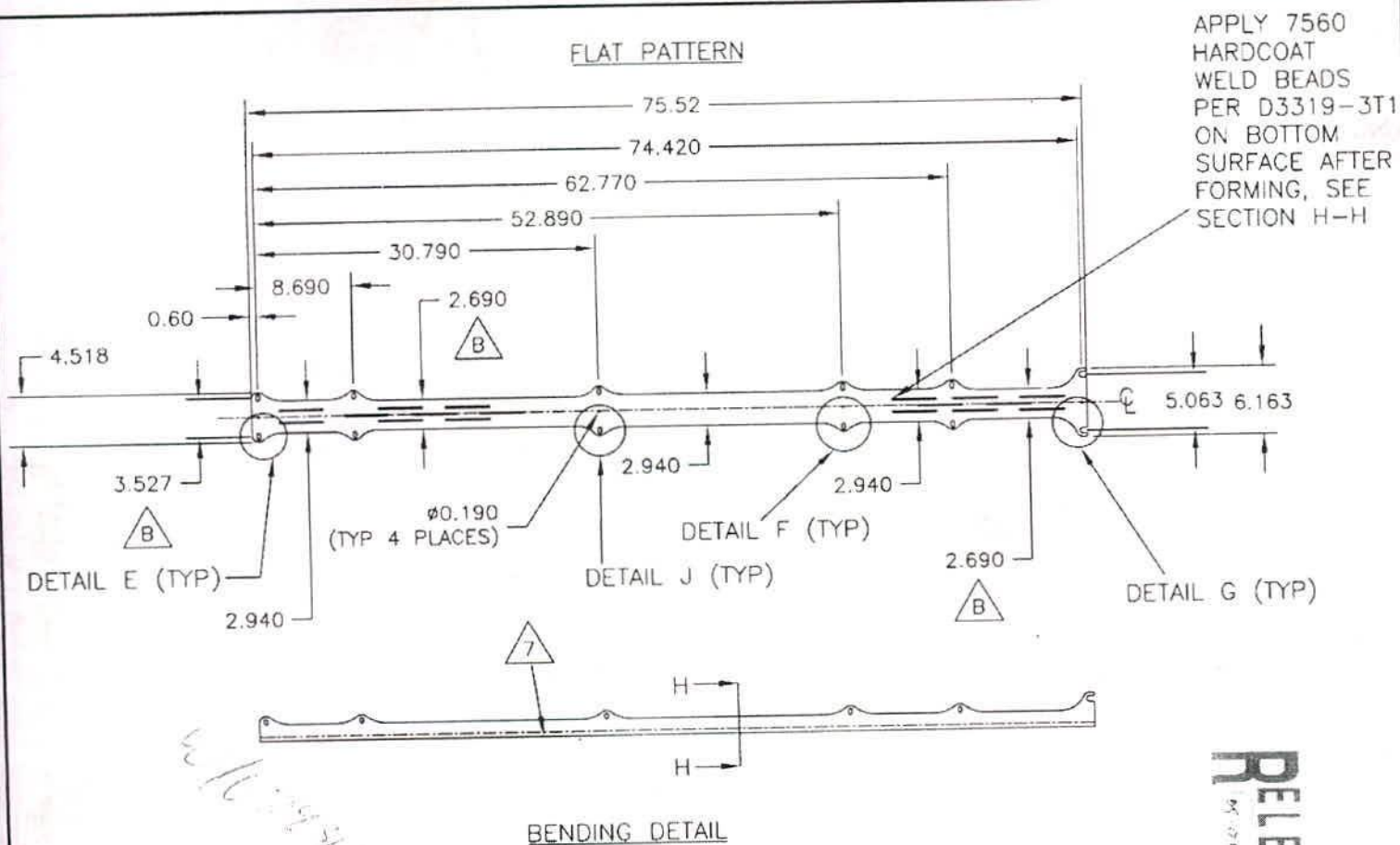
08/05/21

Comment: FINAL INSPECTION/W/O RELEASE

MF 08-05-21

Job Completion





DART

RELEASED

DESIGN	AW	DRAWN BY	AW	DART AEROSPACE LTD
CHECKED	AW	APPROVED	AW	HAWKESBURY, ONTARIO, CANADA
DATE	05.06.06	TITLE	WEARPLATE	REV. B
		DRAWING NO.	D3319	SHEET 2 OF 5
		SCALE	1:15	

D3319-3 WEARPLATE



- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A1008 OR CSA G40-21, 38W/44W/50W/60W/70W SERIES STEEL 18 GAUGE (0.048 THICK)
- 2) FINISH: POWDER COAT GREY SANDTEX (REF.4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) PART IS SYMMETRICAL ABOUT CENTERLINE
- 5) ALL DIMENSIONS IN INCHES
- 6) WELD PER DART QSI 004
- 7) IDENTIFY ON INSIDE SURFACE AS INDICATED USING FINE POINT PERMANENT INK MARKER:
"TCCA-PDA, DART AEROSPACE LTD., P/N D3319-3 B/N BXXXXX,
FOR PRODUCT ELIGIBILITY SEE PDA05-18"

ART AEROSPACE LTD		Work Order: 39313
Description: WEAR PLATE		Part Number: D3319-3
Inspection Dwg: D3319-3 Rev: B		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø .190	+ .005 - .001	.190	X			
Ø .316	+ .006 - .001	.316	X			
.607	+ .008 - .001	.608	X			
Ø .500	+ .005 - .001					
Ø .316	+ .006 - .001	.317	X			
.500	+ .008 - .001					
3.527	+/- .016	3.526	X			
4.518	+/- .010	4.516	X			
2.940	+/- .010	2.949	X			
2.690	+/- .010	2.696	X			
5.063	+/- .010	5.063	X			
6.163	+/- .010	6.165	X			
.60	+/- .030	.595	X			
8.690	+/- .010	8.690	X			
30.790	+/- .010	30.790	X			
52.890	+/- .010	52.890	X			
62.770	+/- .010	62.770	X			
74.420	+/- .010	74.420	X			
75.52	+/- .030	75.52	X			

Measured by: HB	Audited by: 	Prototype Approval: 
Date: 8-5-20	Date: 08/05/20	Date: 1/9

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	